

Nb1.27

Work Order ID 109284

109284

November-18-13 12:43:20 PM

Item ID: D4784-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4784	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									DAS 26 9-89
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4786 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

13/11/27

1x 13-11-25

1x d 12/11/25

1

Work Order ID 109284

November-18-13 12:43:20 PM

109284

Page 2

Item ID: D4784-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00					DAS 6 9-89		
130									
Packaging	Memo	0.00		PP 107173					
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

[Signature] / RM 13/11/29.
MF
13-11-29

Picklist Print

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Page 1

Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.18 NEW ISSUE DD VERF:JLM IPP REV:B 13.06.17 as per dwg
rev.A DD VERF:JLM IPP REV:C 13.06.17 as per dwg rev.pb1 DD VERF:JLM
IPP REV:D 13.06.21 DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No				Each	11.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		11							
				106639		10							
				92130		1							
D2535 Spring		Manufactured	No				Each	108.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST011		108							
				100552		98							
				102576		10							
D2537 Bushing		Manufactured	No				Each	108.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST011		108							
				100454		12							
				102982		30							
				103608		24							
				103861		40							
				98426		2							
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No				Each	0.0000					

310928¹ (1x) 13/11/25

Picklist Print

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Page 2

Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No
Washer

Each 133.0000

6

SP

Location	Loc Qty	Loc Code
ST070	133	
100397	2	
<u>103536</u>	11	
104859	120	

2x

D3953-3 Manufactured No
Gas Spring Stud, Lid

Each 30.0000

2

SP

Location	Loc Qty	Loc Code
GA	1	
87592	1	
ST075	29	
102196	1	
106870	14	
<u>88494</u>	14	

2x

D3953-7 Manufactured No
Spring Spacer

Each 62.0000

2

SP

Location	Loc Qty	Loc Code
ST075	62	
102928	23	
105465	39	

2x

D3953-9 Manufactured No
Gas Spring Washer

Each 73.0000

2

13-11-25

Location	Loc Qty	Loc Code
ST075	73	
102166	21	
<u>103615</u>	26	
107922	26	

2x

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Shop Packet Print

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No
Gas Spring Spacer

Each 56.0000

2

Location	Loc Qty	Loc Code
ST076	56	
102860	16	
106073	40	

D3953-19 Manufactured No
Gas Spring Bracket

Each 48.0000

1

Location	Loc Qty	Loc Code
ST076	48	
104984	24	
107604	24	

D3953-21 Manufactured No
Gas Spring Bracket

Each 36.0000

1

Location	Loc Qty	Loc Code
ST076	36	
105028	12	
107641	24	

D3969-3 Manufactured No
Gas Spring

Each 38.0000

Location	Loc Qty	Loc Code
ST262	38	
100611	22	
99623	16	

D4785-041 Manufactured No
Long Basket Base Assembly, LH/RH

Each 0.0000

D4786-210 Manufactured No
Placard, Max Load

Each 0.0000

DAS
26
9-89

13-11-25

13109289 (1x) 11/13/11/25
13109293 (1x) 11/13/11/25

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

AN3-14A Purchased No

Each 153.0000

4

DAS

26

9-89

Location Loc Qty Loc Code

ST351 101

m125709 1

m127044 100

ST511 51

m126192 51

ST512 1

123759 1

4x

AN3-16A Purchased No

Each 187.0000

2

DAS

26

9-89

Location Loc Qty Loc Code

GA 47

117441 47

ST352 140

122407 8

M125952 4

M126192 78

M127070 50

2x

AN310C4 Purchased No

Each 91.0000

2

DAS

26

9-89

Location Loc Qty Loc Code

ST342 91

126192 41

M125952 50

2x

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

Each 103.0000

3

DAS
26
9-89

Location	Loc Qty	Loc Code
ST342	103	
112969	2	
122800	2	
M125716	1	
M126400	48	
M126872	50	

3x

DAS
26
9-89

AN4-12 Purchased No

Each 86.0000

3

Location	Loc Qty	Loc Code
ST356	86	
124805	5	
m125709	50	
m126193	31	

3x

AN5-17A Purchased No

Each 353.0000

4

DAS
26
9-89

Location	Loc Qty	Loc Code
GA	36	
117872	36	
ST337	4	
124215	2	
124805	2	
st503	163	
m126176	163	
ST514	150	
125388	150	

4x

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3	Purchased	No	Each	7,565.0000	6	DAS 26 9-89
Nut						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST314	1035	
M126036	35	
M127304	1000	
ST506	814	
123900	814	
ST509	3000	
M127410	3000	
ST510a	2716	
M126275	8	
M126333	2708	

MS21042L5	Purchased	No	Each	996.0000	4	DAS 26 9-89
Nut						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
st507	496	
125535	496	
ST509	500	
m127304	500	

MS24665-151	Purchased	No	Each	235.0000	3	DAS 26 9-89
Cotter Pin						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	28	
17566	28	
ST323	207	
122802	20	
124859	4	
125646	83	
m127305	100	

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

MS24665-300 Purchased No

Each 129.0000

2

DAS
26
9-89

Location	Loc Qty	Loc Code
GA	37	
118234	37	
ST299	92	
124555	92	

NAS1149F0332P Purchased No

Each 7,540.0000

8

DAS
26
9-89

Location	Loc Qty	Loc Code
GA	182	
122063	182	
ST294	158	
122063	158	
ST295	3	
123352	3	
st510	2197	
123900	2197	
ST510a	5000	
125646	5000	

NAS1149C0432R Purchased No

Each 6,152.0000

2

DAS
26
9-89

Location	Loc Qty	Loc Code
ST292	2320	
119124	6	
121255	8	
121825	8	
122441	55	
m125807	2251	
ST510a	3832	
m126221	3832	

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Work Order ID: 109284

Parent Item: D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 11/18/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

Each

1,157.0000

6

DAS
26
9-89

WASHER

Location

Loc Qty

Loc Code

ST510a

1157

M126221

1157

6x

DAS
26
9-89

NAS1149F0563P

Purchased

No

Each

542.0000

4

13-11-25

Washer

Location

Loc Qty

Loc Code

ST295

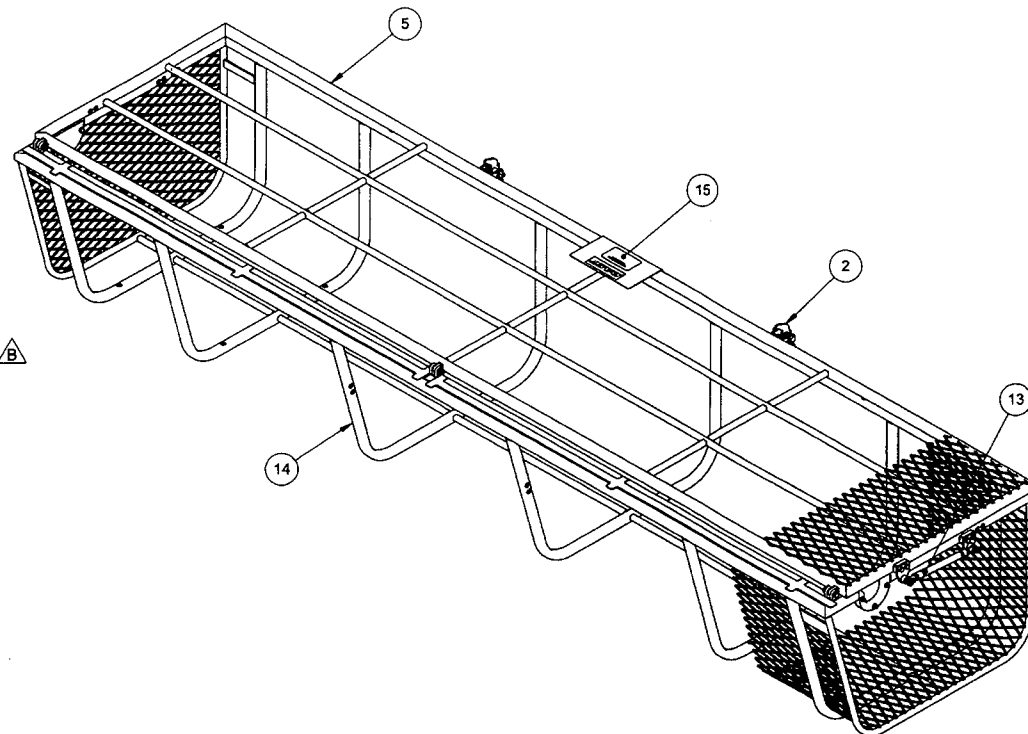
542

121350

542

4x

ITEM NO.	QTY. -011	PART NUMBER	DESCRIPTION
1	X	D4784-011	BASKET ASSY, HEAVY DUTY LID, LH/RH
2	1	D2530	HANDLE WELOMENT
3	2	D2535	SPRING
4	2	D2537	BUSHING
5	1	D3914-041	LONG BASKET LID ASSY
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3553-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	2	D3969-3	GAS SPRING
14	1	D4785-041	LONG BASKET BASE ASSY
15	1	D4786-210	PLACARD
16	4	AN3-14A	BOLT
17	2	AN3-16A	BOLT
18	2	AN310C4	NUT, CASTELLATED
19	3	AN310-4	NUT, CASTELLATED
20	3	AN4-12	BOLT
21	4	AN5-17A	BOLT
22	6	MS21042L3	NUT
23	4	MS21042L5	NUT
26	3	MS24665-151	COTTER PIN
27	2	MS24665-300	COTTER PIN
28	8	NAS1149F0332P	WASHER (AN960-10L)
29	2	NAS1149C0432R	WASHER (AN960-416L)
30	6	NAS1149F0432P	WASHER (AN960-416L)
31	4	NAS1149F0563P	WASHER (AN960-516)



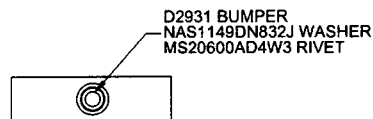
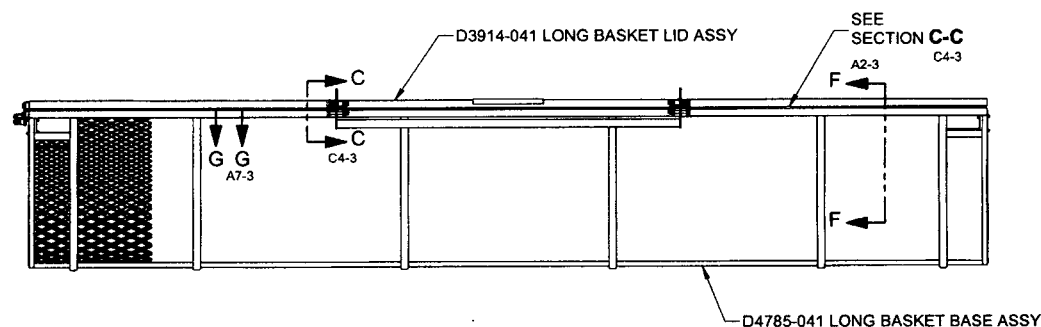
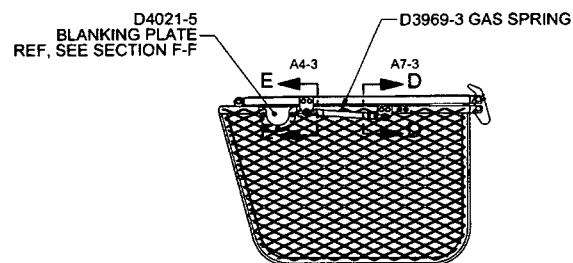
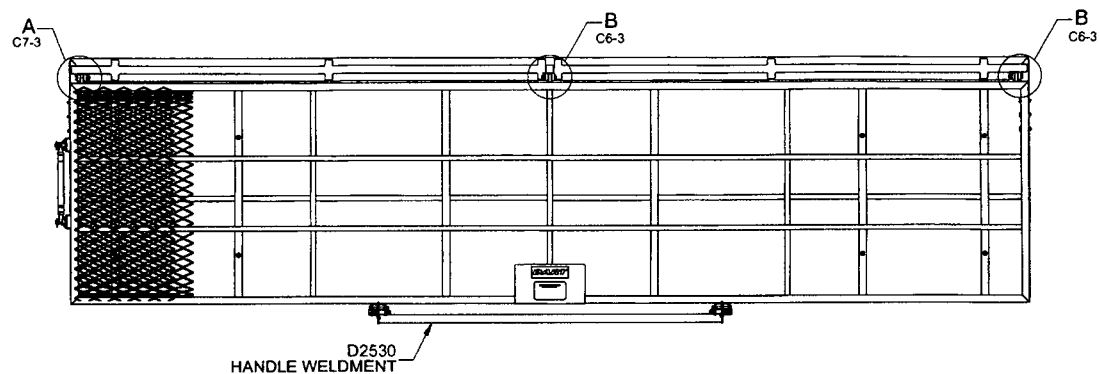
D4784-011 BASKET ASSEMBLY, HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 80.10 lbs

info 109284

RELEASED
 2013-06-20
wp




B	REVISE D4785-041 SHOWN	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>DC</i>		
MFG. APPR.	<i>IS</i>		
APPROVED	<i>IS</i>		
DE APPR.	<i>IS</i>		
DATE	13.06.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4784 TITLE BASKET ASSEMBLY SCALE NTS SHEET 1 OF 3 REV. B COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



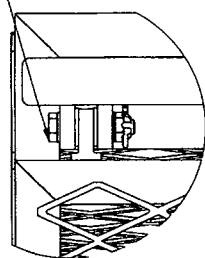
B5-3
SECTION G-G
(LID ASSY REMOVED FOR CLARITY)

D4784-011 BASKET ASSEMBLY, HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

RELEASED
2013-06-20

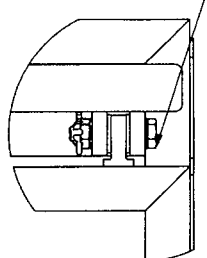
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.		D4784	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY	NTS
DATE	13.06.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



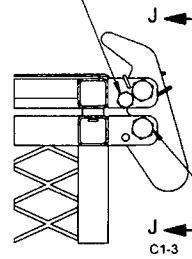
DETAIL A D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



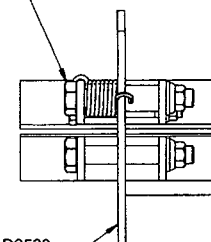
DETAIL B D2-2
D4-2

AN3-16A
MS21042L3 NUT



SECTION C-C B5-2
C2-2

AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

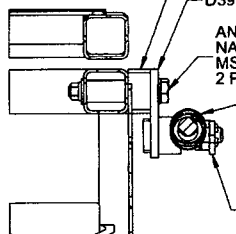
VIEW J-J C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3969-3 GAS SPRING
REF

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

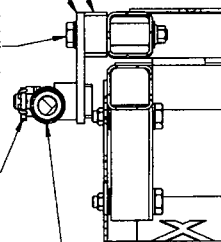


SECTION D-D B7-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

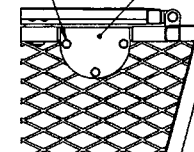
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN



D3969-3 GAS SPRING
REF

SECTION E-E B7-2

AN3-10A BOLT
NAS1149F0332P WASHER
MS21042L3 NUT
3 PL, REF



D4021-5
BLANKING PLATE
REF

SECTION F-F B2-2

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DA	D4784	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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